

Work Order ID 51124

August 4, 2009 11:05:17 AM

Page 1

Item ID: D2530

Accept

Revision ID: B

Item Name: Handle Weldment

Start Date: 8/07/09 Start Qty: 10.00

Required Date: 8/28/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: umf

Date: 09-08-04 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2530 | Rev B | | | | | | | | |

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut to length as per Dwg D2536□2-Debur

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301□2-Debur

Handwritten signature and date: 09/08/05 (10)

Handwritten note: => 8/08/05

Handwritten circled number: (10)

Handwritten initials: DO

Handwritten date and circled number: 09-08-06 (10)

Work Order ID 51124

August 4, 2009 11:05:17 AM

Page 2

Item ID: D2530

Accept

Revision ID: B

Item Name: Handle Weldment

Start Date: 8/07/09 Start Qty: 10.00

Required Date: 8/28/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

130 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

09-08-07

140 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

2) 8/9/08/07

(410)

d

150 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00



Powdercoat Memo 0.00

Powder Coating

1109091

START TIME: *10:00 AM* FINISH TIME: *10:30 AM* OVEN TEMPERATURE: *320°F*

=) 09-08-11

(x10)

24

Work Order ID 51124



Page 3

August 4, 2009 11:05:17 AM

Item ID: D2530

Accept



Setup Start



Revision ID: B

Stop



Item Name: Handle Weldment

Start Date: 8/07/09 Start Qty: 10.00



Cust Item ID:

Required Date: 8/28/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 160 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | => Sorlosu | | | (48) | f | | |
| 170 Packaging Packaging | Identify as per dwg & Stock Location: <u>SOP</u> Memo | 0.00 0.00 | MO 09/08/11 | | | X10 | SP | | |
| 180 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | 090812 A |

C209/08/12

Picklist Print

August 4, 2009 11:05:17 AM

Page 1 / 1

Work Order ID: 51124

Parent Item: D2530RevB

Parent Item Name: Handle Weldment


Comments:

Start Date: 8/07/09

Required Date: 8/28/09

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2534RevD | | Manufactured | No | | | 100 | Each | 30.0000 | 20.0000 | | | |
|  | | | | | | | | | | | | |
| Lock Plate | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 30

47176 30

M304TR0.750W.049

Purchased

No

120

f

350.2300

30.6789



304 RD Tube .750 x .049W

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT 350.2300026

107518 7.27

108498 0

109314 8.5

110113 0.73

110271 0.03

111096 9

111457 11.43

111619 13.2700026

112187 300

25 PD 09.08.06

30.678



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

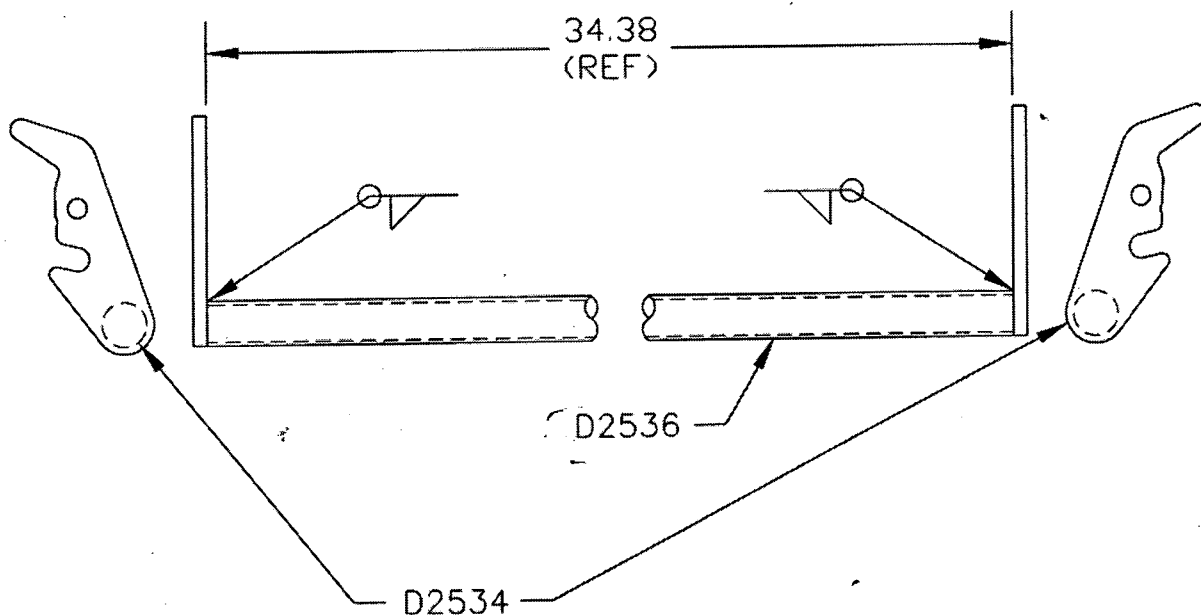
#51124 mf 09-08-04

DART

| | | | |
|----------------------------|-----------------------------|--|------------------------|
| DESIGN B WILLIAMS | DRAWN BY PH | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2530 | REV. B SHEET 1 OF 1 |
| DATE 04.12.14 | | TITLE HANDLE WELDMENT | |
| A | 96.06.18 | NEW ISSUE | |
| B | 04.12.14 | UPDATE NOTES AND DIMENSIONS | |

RELEASED04.12.16 *[Signature]*PART LIST -- D2530

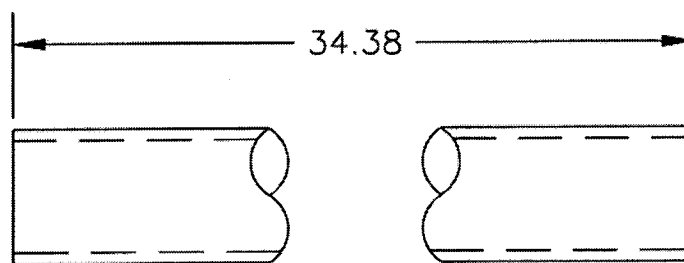
| QTY | PART NUMBER | DESCRIPTION |
|-----|-------------|-----------------|
| X | D2530 | HANDLE WELDMENT |
| 1 | D2536 | HANDLE |
| 2 | D2534 | LOCK PLATE |

D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN B WILLIAMS | DRAWN BY PH | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2536 | REV. B SHEET 1 OF 1 |
| DATE 04.12.14 | | TITLE HANDLE | SCALE NTS |
| A | 96.05.15 | NEW ISSUE | |
| B | 04.12.14 | UPDATE NOTES | |

RELEASED04.12.16 *[Signature]***REFERENCE ONLY***WID 51124***D2536 HANDLE**

- 1) MATERIAL: AISI 304/316 SS $\phi 0.75$ X 0.049 WALL (REF. DART SPEC. M304TRO.750W.049)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED